

Work Order ID: 52357

September 22, 2009 10:41:35 AM

Page 1

Item ID: D119-646-211

Accept

Setup Start

Revision ID: B

Stop

Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: mf

Date: 09-09-29 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D119-646

B

100

0.00

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D119-646-211  
CHG001

0.00

809/12/14

110

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

9/10/8 40 54

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

809/12/14

40 41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52357

September 22, 2009 10:41:35 AM



Page 2

Item ID: D119-646-211

Accept



Setup Start



Revision ID: B

Stop



Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-646-211

Location:

PPP rev: D/REJ

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/14 (1)

09/12/17 HJ

W.O. 12.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

September 22, 2009 10:41:34 AM

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... ..

**Required Date:** 10/22/2009

**Required Qty: 1.00**

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 52357

Parent Item: D119-646-211RevB

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2652RevA

Manufactured

No

110

Each

330.0000

16.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

44

31985

44

Main Warehouse

ST

203

21091

0

45318

16

46608

12

48187

175

Main Warehouse

ST40

83

50271

83

AN3C50A

Purchased

No

110

Each

60.0000

8.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

112046

10

112454

50

50271/50

112046  
112454  
3  
9/10/8  
50

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



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Work Order ID: 52357

Parent Item: D119-646-211RevB

Parent Item Name: Skidtube STD w/ Training Wearplates, LH



Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4C6A  Bolt		Purchased	No			110	Each	166.0000				

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

4

103344

4

Main Warehouse

ST

162

111724

162

MS21250-05-006

Purchased

No

110

Each

122.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

122

112046

22

112657

100

111724 50

112046 9/10/8 QSO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 52357

Parent Item: D119-646-211RevB

Parent Item Name: Skidtube STD w/ Training Wearplates, LH


Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			110	Each	6,964.000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	6864	
112116	1864	
112612	5000	

112116 SP

AN960C416L

Purchased

No

110

Each

1,112.000

24.0000

WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	44	
104925	44	
Main Warehouse		
ST	1068	
111808	63	
111916	5	
112612	1000	

9/10/8 @ SP

112492

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 52357

Parent Item: D119-646-211RevB

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C516L

Purchased

No

110

Each

345.0000

8.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

109545

12

111650

33

111916

300

Purchased

No

110

Each

5,320.000

8.0000

MS21043-3



Nut

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

5240

111819

78

112243

186

112314

4976

11916 SP

112314

9/10/8 (123)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 52357

Parent Item: D119-646-211RevB

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4 S Nut		Purchased	No			110	Each	1,397.000	13.0000			

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST	1357	
111819	35	
112243	22	
112314	1000	
112492	300	

11231450

D2712RevB

Set Screw

Manufactured No

110 Each

451.0000 12.0000

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	50	
29962	50	
Main Warehouse		
ST	401	
16400	20	
43810	11	
45247	25	
47603	145	
48235	200	

47603 9/10/8 12 8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 52357



Parent Item: D119-646-211RevB



Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S D3672-7RevB  Phenolic Washer		Manufactured	No			110	Each	790.0000	24.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 790

35522 290

51696 500

S D3672-3RevB



Phenolic Washer

Manufactured No

110

Each

919.0000

24.0000



51696 50

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 419

34471 56

48258 363

Main Warehouse

ST117 500

51596 500

48258 9/10/08 50 @

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

September 22, 2009 10:41:34 AM

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Work Order ID: 52357

Parent Item: D119-646-211RevB

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3407-041RevE

Manufactured

No

110

Each

35.0000

1.0000

Tow Ring

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

3

35780

3

Main Warehouse

ST

1

48356

1

Main Warehouse

ST464

31

51659

31

D3417-5RevE

Manufactured

No

110

Each

152.0000

1.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

152

51649

152

B51926 09/10/13

9/10/09 10

51649 54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 09/30/2009

Required Date: 10/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3456-1RevA		Manufactured	No			110	Each	232.0000	1.0000			



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	7	
25701	7	
Main Warehouse		
ST	225	
46752	25	
51653	200	

D3417-7RevE

Manufactured No

110

Each

30.0000

1.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST90	30	
51645	30	

51653 SP

9/10/8 RD SP

51645 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE USA, INC.

REFERENCE ONLY  
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## 4.0 PARTS LIST

## 4.1 Standard Skidtubes

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
	X												D119-646-011	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-012	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-111	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-112	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-211	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-212	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-041	REPLACEMENT STANDARD SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-141	REPLACEMENT STANDARD SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-151	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-241	REPLACEMENT STANDARD SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-251	TRAINING WEARPLATES STANDARD SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3887-041	STANDARD SKIDTUBE ASSY. WITH WEARPAD
20								1					D3887-043	STANDARD SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-047	AFT WEARPLATE ASSY
29									5				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									30				AN3C5A	BOLT
32									30				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3887-045	STANDARD SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-041	FWD TRAINING WEARPLATE ASSY
45											1		D3849-043	AFT TRAINING WEARPLATE ASSY
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)

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Revision: B  
Date: 09.06.29

52357

# REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D119-646

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Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	1	1	1	1	1	1							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
84	1	1	1	1	1	1							D3417-7	WASHER
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT

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